



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6798927-4

Job Sheet 178391



DL-S

ds

2940
3524

SHIP
7-20

NO
FAIL

Part No: RB6798927-4

Job Qty: 6 ea

Part Name: Set Screw / Modified B/O



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 7/3/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB6798927 Rev.2 IPP Rev. A 18.05.30 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Machining-4		JB 18-07-10
100	Lathe Conv	6 pcs	7/3/18	7/3/18	0.50	0.50	Lathe Conv-2		JB 18-07-10
110	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Machining-5		JB 18-07-10
120	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC8 Machining-5		JB 18-07-11
130	Outsource	6 pcs	7/3/18	7/3/18	0.00	0.00	Outsource12		18-07-25
140	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging2		38
150	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC6		38
160	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging3-2		21
170	QC21-SA	6 Ea	7/3/18	7/3/18	0.00	0.00	QC21		21

Part Op 100 - 1-Machine as per DWG. 2-Deburr

Descriptions: 130 - Issue P/O to GROUPE ALTECH; PO 040465 - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required

140 - Receive

160 - IDENTIFY AND STOCK

JUL 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92695A307	Cone Point Set Screw	6 Ea (1 ea)	90-Start up Operation	5079641
				GA055

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	92695A307	6	25	0

Part Specifications

Specifications could not be found.

Plex 6/18/18 7:40 AM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S090308



Part: RB6798927-4

Job No: 178391

Serial No/Batch: S090308

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 07/25/18

2A0

8E

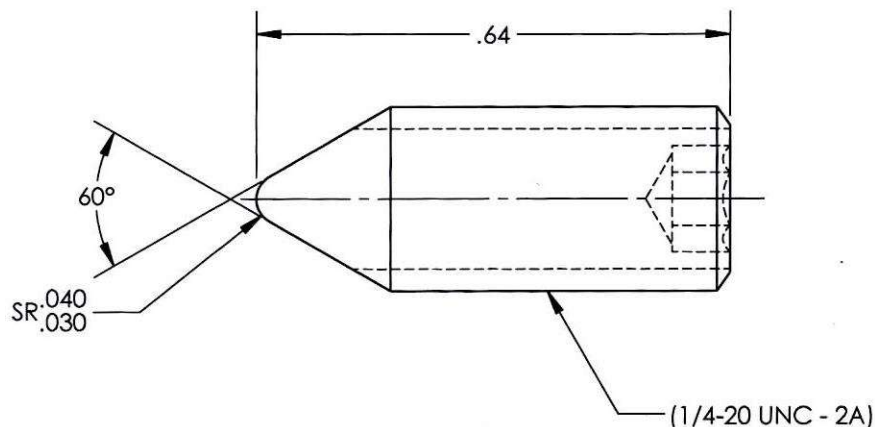
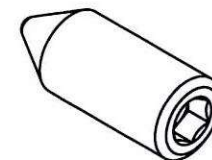
98-E

73

71

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-4 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D.	4/27/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 178391

20180619



TITLE CRIMPER-LOCK NUT COMPRESSOR
IMPELLER ASSY AND TURBINE POWER SHAFT

DWG NO. RB6798927-4

REV 2

MAT'L STEEL

HEAT TREAT

FINISH BLACK OXIDE

SPEC QMSI-6.2.2, B.O. REV D

DRAWN BY: DD 04/27/2017

CHECKED: RJC 05/02/2017

OPPS APPR: AA 05/05/2017

QA APPR: JL 05/10/2017

APPROVED: JAG 05/18/2017

SCALE 4:1

DATE 4/27/2017

SHEET 8 OF 8

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .02 ANGLES ± 1°
.X ± .1 SURFACES = 125/

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

(-4)

CONE POINT SET SCREW

178391

Page 1 of 1

.64	$\pm .020$	.6395	✓	vernier	VHS - on
60°	$\pm .01$	60°	✓	↓	↓
SR .040	$\pm .010$	.035	✓	↓	↓
1/4 - 20 unc	—	1/4 - 20 unc	✓	—	—

Measured by:	JB 118
Date:	18-07-10

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		☐ Rework	☐ Scrap	☐ Skid-tube	☐ Machining	☐ Cross tube	☐ Small Fab	☐ Water Jet	☐ Engineering
NCR No. _____		☐ Use-as-is		☐ Thermoforming	☐ Large Fab	☐ Finishing	☐ Composite	☐ Rec/Store/Packaging	☐ Supplier
Date: _____	Step #: _____								
Description Work Order I									
Completed By _____									
Lead hand / Supervisor Approval Verification									
QC / QA Coordinator Approval									

Root Cause		Environment		Design		Doc/Data		Equip/Tooling		Handling/Pre		Material		Internal Transport		Tribal Knowledge		LOA		Substation		Past Expiry Date		Misidentified	
☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
No Re-Verification		Operator		Offset/Setup		Supplier		Training		Use for Testing		Poor Information		Rushing		Product Improvement		Process Improvement		Manufacturing Process		Past Due			

Cracks		Crimp/Kink/Ripple/Wave		Cuffs		Crushing		Heat Treat		Wave/Twist in Tube		Marks/Chatter		Broken/Damage/Vermin		Inspection Incomplete/Unqualified		Contamination		Countersink		Cut Too Short		Instructions Incomplete/Unclear		Drill Holes		Wrong Stock Pulled		Out of Sequence		Off-set		Mislabeled		Fit/Function		Misaligned/off center		Positioned Wrong		Outside Dimensions		Over/Under tolerance		Part Incorrect		Part Lost/Missing		Part Moved		Drawing		Finish		Misread		Turning Sequence	
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OTHER :	
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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
Container No: S090308
Part: RB6798927 - 4
Job No: 178391
Serial No/Batch: S090308
Revision: 2
Inspector:
Exp Date:
Instructions:

Date: 07/10/18

Certificat de Conformité / Certificate of Compliance

(011173-2)



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011173- 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
24-Jul-2018		Aman			040465			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE-350DAMPER Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
4	RB6798927-4 Rev.	RB6798927-4 MIL-C-13924C CLASS 1 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0
5	RBE350A94-2706-00-05 Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	3	3	0	0	0
6	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
7	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	12	12	0	0	0
8	RBE350A94-2706-00-07 Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
9	RBE350A94-2706-00-09 Rev.	RBE350A94-2706-00-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
10	RBA9935 Rev.	RBA9935 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
11	RBW6705G00632-3G-11 Rev.	RBW6705G00632-3G-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0

DAS
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011173- 2

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Notes Additionnelles / Additional Notes

Réçu par
Received By

User ID AMAN



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040465**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040465
PO Date: 7/11/18
Due Date: 7/20/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173844	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$2.35/pcs	\$14.10
2	174441	RBW6305G00232-3G-5	Stop -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/20/18	12 pcs	0 pcs	12 pcs	\$11.80/pcs	\$141.60
3	174442	RBW6305G00232-3G-7	Stud -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/20/18	13 pcs	0 pcs	13 pcs	\$11.80/pcs	\$153.40

JUL 24 2018

JUL 24 2018

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9-89

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178391	RB6798927-4	Set Screw / Modified B/O -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.60/pcs	\$9.60
5	172443	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	3 pcs	0 pcs	3 pcs	\$1.50/pcs	\$4.50
6	173903	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	24 pcs	0 pcs	24 pcs	\$1.50/pcs	\$36.00
7	173905	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	12 pcs	0 pcs	12 pcs	\$1.50/pcs	\$18.00
8	173909	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.50/pcs	\$9.00

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	173911	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.55/pcs	\$9.30
10	177149	RBA9935	Draw Bolt -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.75/pcs	\$10.50
11	178632	RBW6705G00632-3G-11	Washer -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Material; 1018 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.50/pcs	\$9.00
Grand Total:											\$415.00
Order Notes											
											

Order Notes**Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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